

# Work Order ID 72237

Wednesday, July 20, 2011 9:07:13 AM



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Item ID:	D6207	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Angle Extrusion					
Start Date:	7/20/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	7/27/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/07/20</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D6207	Rev A								

100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>14 566</u> <input type="checkbox"/> a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125" <input type="checkbox"/> b) Material: 6061-T6/T6511 (QQ-A-200/8) <input type="checkbox"/> c) Minimum ultimate tensile strenght = 38 ksi <input type="checkbox"/> d) Minimum yield tensile strenght = 35 ksi								

CL 11/07/22 20

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

Pup/s/2 (20)

120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6207 Check hardness with Webster tester								

11/08/03

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72237**

Wednesday, July 20, 2011 9:07:13 AM

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Item ID: D6207

Accept

Revision ID:

Item Name: Angle Extrusion

Start Date: 7/20/2011 Start Qty: 20.00

Required Date: 7/27/2011 Req'd Qty: 20.00



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>MAT</u>  Memo	0.00  0.00		<u>CR 11/08/03</u>		<u>20</u>			
140  QC	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>CR 11/08/04</u>
Quality Control									<u>11-08-2</u> <u>20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

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Wednesday, July 20, 2011 9:07:11 AM

Work Order ID: 72237



Parent Item: D6207

Parent Item Name: Angle Extrusion



Start Date: 7/20/2011

Required Date: 7/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A: ☐02.03.15 ☐New Issue NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207P  Angle Extrusion 1x1x.125		Purchased	No			110	f	0.0000	1 	20			

*Handwritten signature: Pu/s/s*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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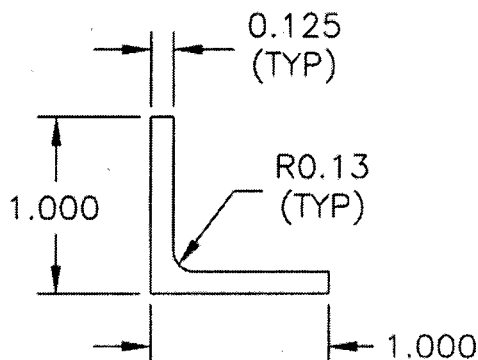
NOTE: Date & initial all entries



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED  
02.03.13

## SPECIFICATION CONTROL DRAWING



D6207-XXX ANGLE EXTRUSION  
WHERE XXX IS LENGTH IN INCHES

EG.  
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE  
1.000" x 1.000" x 0.125"  
6061-T6/T6511 (QQ-A-200/8)  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

CL 11/07/20  
WRO. 72237

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries





TÉLÉPHONE: (418) 831-4444  
TÉLÉCOPIEUR: (418) 831-7400  
SANS FRAIS: (800) 704-4244  
770 Chemin Olivier, St-Nicolas, Québec G7A 2N2

## CERTIFICAT DE CONFORMITÉ

Ce certificat garantit que le matériel décrit ci-dessous a été produit  
conformément au manuel d'assurance qualité d'EXTRUDEX

ALUMINIUM (QUÉBEC) S.E.C., selon les normes:

(AMS-QQ-A-200/8)

NOM DU CLIENT: MAGNA STAINLESS INC.

VOTRE NUMÉRO DE COMMANDE: 13595

NOTRE NUMÉRO DE COMMANDE: 70039 - 1

NUMÉRO DE FILIÈRE: SA01092 - 1

DESCRIPTION ITEM: ANGLE 1 X 1 X 1/8 (R)

ALLIAGE: 6061

TREMPAGE: T6

NUMÉRO DE COULÉE: 12602

### COMPOSITION CHIMIQUE DE LA COULÉE:

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Ga	V	B	Zr	Bi	Pb	Sn	Sr	Co	Al
57	0.22	0.20	0.06	0.82	0.06	0.00	0.01	0.02	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00

SIGNATURE: 

